

Work Order ID 68283

Monday, April 11, 2011 12:49:39 PM



Page 1

Item ID: D2877

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle Spacer

Start Date: 4/11/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

11-04-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2877	Rev B								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2877 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-deburr

6561.125

B11-4-11

(60)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-4-11

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

M

11

04

12

(60)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




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Item Name: Saddle Spacer				
Start Date: 4/11/2011	Start Qty: 40.00		Cust Item ID:	
Required Date: 4/15/2011	Req'd Qty: 40.00		Customer:	
Reference:				

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	Deburr if necessary								
140 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									
150 	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00							
Quality Control									

11-4-11
 60
 11/04/12 34
 60 11-4-12

W/O:		WORK ORDER CHANGES						
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Setup Start



Revision ID:

Stop



Item Name: Saddle Spacer

Start Date: 4/11/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 4/15/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: 25

0.00



Packaging

Memo

0.00

Packaging

11/4/11 25 60

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/11 40

11-04-13
60

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 68283



Parent Item: D2877



Parent Item Name: Saddle Spacer



Start Date: 4/11/2011

Required Date: 4/15/2011

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP B ☐ 00.05.19 ☐ Added inspect level 8 ☐ EC
 IPP C ☐ 06.04.26 Water jet ☐ EC
 IPP Rev:D Now M6061-T6 06-06-23 JLM
 IPP Rev:E Updated Thickness as per Rev B 06-09-18 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.125 		Purchased	No			110	sf	136.9000	0.0607	2.555789	4.		
6061-T6 .125 Sheet											B 11-4-11		

Location

Loc Qty

Loc Code

MAT021

136.9

113608

112.9

116700

24

113608

(66)

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

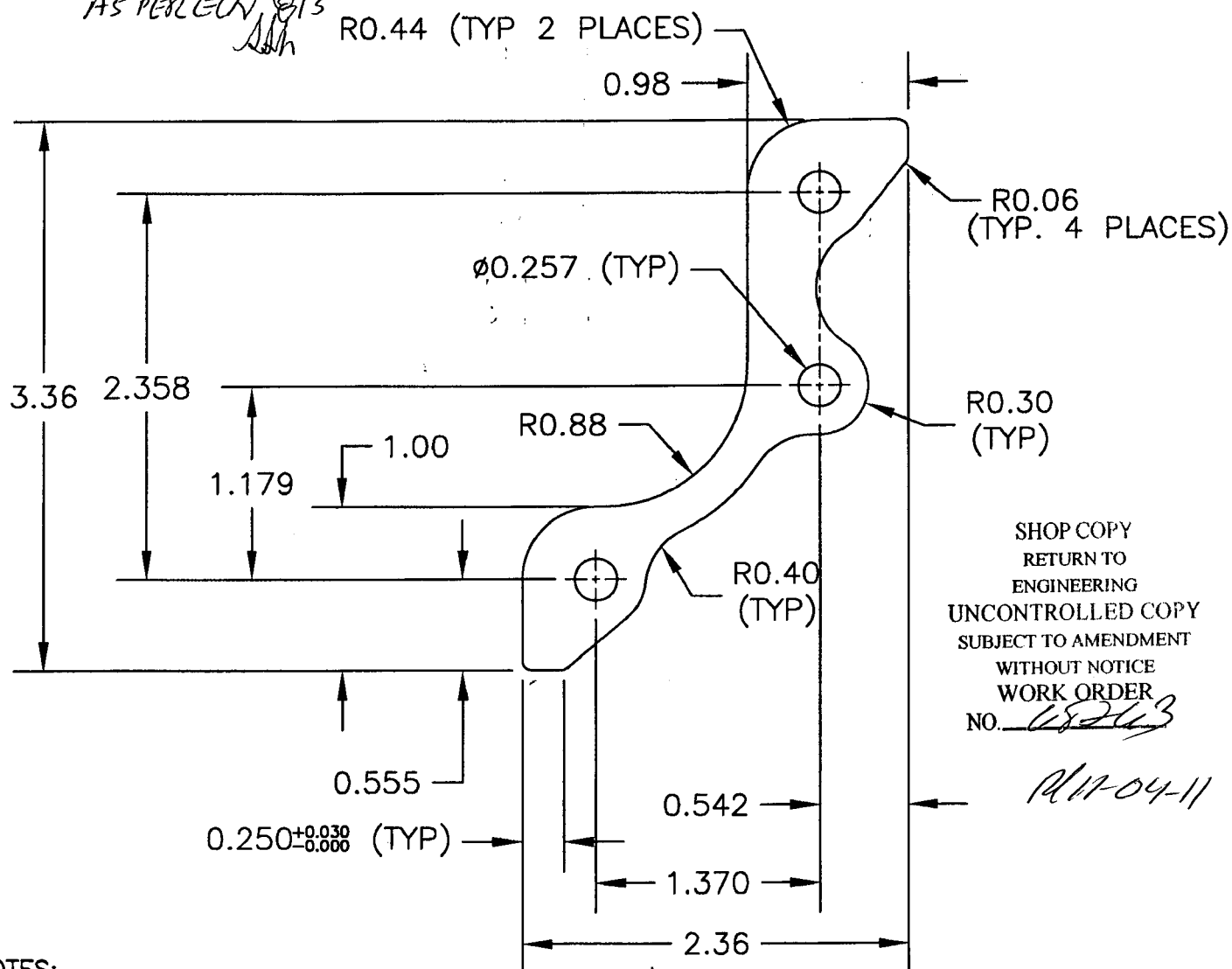
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DART

DESIGN <i>CP</i>	DRAWN BY <i>C.B.</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2877	REV. B SHEET 1 OF 1
DATE 06.05.17		TITLE SADDLE SPACER	SCALE 1:1
A	99.02.23	NEW ISSUE	
B	06.05.17	THICKNESS WAS 0.100", MAT CHANGE	

RELEASED
*06.06.21**AS PER ECN 813*

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *68263*

*11-04-11***NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (QQ-A-250/11) 0.125" THICK
(REF DART SPEC M6061T6S.125)
OR
5052-H32/H34 ALUMINUM SHEET (QQ-A-250/8) 0.125" THICK
(REF DART SPEC M5052H32S.125)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) ALL DIMENSIONS ARE IN INCHES

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